
**Plywood — Classification by surface
appearance —**

**Part 2:
Hardwood**

Contreplaqué — Classification selon l'aspect des faces —

Partie 2: Bois feuillus

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ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Fax: +41 22 749 09 47
Email: copyright@iso.org
Website: www.iso.org

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 89, *Wood-based panels*, Subcommittee SC 3, *Plywood*.

This second edition cancels and replaces the first edition (ISO 2426-2:2000), which has been technically revised.

The main changes compared to the previous edition are as follows:

- It is precised that hardwood species includes tropical and temperate hardwood.

A list of all parts in the ISO 2426 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Plywood — Classification by surface appearance —

Part 2: Hardwood

1 Scope

This document specifies the nature and limits of characteristics inherent in wood and manufacturing defects enabling the visual assessment of the plywood for allocation to an appearance class.

This document applies to plywood, the surface veneers of which are made from hardwood species¹⁾ including tropical and temperate hardwood.

It does not apply to overlaid panels.

2 Normative reference

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 2426-1, *Plywood — Classification by surface appearance — Part 1: General*

3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

4 Classification by surface appearance

4.1 Appearance classes

Assessment of characteristics and defects for determination of appearance class shall be carried out in accordance with ISO 2426-1. Surface classification shall be based on the permissible characteristics and defects within each of the appearance classes as specified in 4.2.

4.2 Permissible characteristics and defects

4.2.1 General

Each surface shall be individually assigned to one of the appearance classes E, I, II, III or IV, as defined by the permissible characteristics according to [Table 1](#) and permissible defects according to [Table 2](#).

1) Conventionally, broadleaved species.

4.2.2 Characteristics inherent in wood

Classification according to characteristics inherent in wood is given in [Table 1](#).

Table 1 — Surface appearance classification of hardwood veneer

Category of characteristics		Appearance class					
		E	I	II	III	IV	
Pin knots ^a		Practically absent	3/m ² permitted	Permitted			
Sound intergrown knots			Permitted up to an individual diameter of:			Permitted, but see Note	
			15 mm provided their cumulative diameter does not exceed 30 mm/m ²	35 mm	50 mm		
			Such knots may have splits provided they are very slight		slight		
Unsound or non-adhering knots and knot holes				Permitted up to an individual diameter of:			Permitted, but see Note
Splits				6 mm if filled and up to a number of 2/m ²	5 mm if unrepaired 10 mm if filled and up to a number of 3/m ²	40 mm	
				Permitted if less than:			Permitted, but see Note
				1/10	1/5	1/3	
				of panel length up to an individual width of:			
3 mm	5 mm		20 mm				
and up to a number of:							
3/m	3/m	3/m					
of panel width							
if properly filled			if unrepaired or unlimited if all filled				
Closed			Permitted				
Abnormalities due to insects, marine borers and parasitic plants		Not permitted	Not permitted	Marks of parasitic plants not permitted. Insects and marine borer holes permitted up to a:		Permitted, but see Note	
			diameter of 3 mm vertically to the plane of the panel up to a number of 10/m ²	width of 15 mm and length of 60 mm up to a number of 3/m ²			
Inbark			Not permitted	Permitted up to a width of:		Permitted, but see Note	
			5 mm if properly filled	25 mm			
NOTE Characteristics inherent to wood are permitted provided that they do not impair the serviceability of the panel.							
^a Pin knots: sound intergrown knots of no more than 3 mm diameter.							

Table 1 (continued)

Category of characteristics	Appearance class				
	E	I	II	III	IV
Irregularities in the structure of the wood	Practically absent	Permitted if very slight if slight		Permitted	
Discoloration which is not wood-destroying		Permitted if low contrast		Permitted	
Fungal decay which is wood-de-destroying	Not permitted				
Other characteristics	Pratically absent	To be considered under the category which they most closely resemble			
NOTE Characteristics inherent to wood are permitted provided that they do not impair the serviceability of the panel.					
a Pin knots: sound intergrown knots of no more than 3 mm diameter.					

4.2.3 Manufacturing defects

Classification according to manufacturing defects is given in [Table 2](#).

Table 2 — Surface appearance classification of hardwood plywood

Category of defect	Appearance class				
	E	I	II	III	IV
Open joints	Not permitted	Not permitted	Permitted up to a width of: 3 mm 5 mm 25 mm		
			and up to a number of: 1/m 2/m unlimited of panel width with joints		
			filled if more than 1 mm in width	unfilled	unfilled
Overlaps		Not permitted	Permitted up to a number of 1/m ² and up to 100 mm length	Permitted up to a number of 2/m ²	Permitted but see Note
Blisters		Not permitted			
Hollows, imprints and bumps		Not permitted	Permitted if slight	Permitted	
Roughness		Not permitted	Permitted if slight	Permitted	
Sanding through		Not permitted		Permitted up to an extent of panel surface of: 1 % 5 % but see Note	
Glue penetration		Not permitted	Permitted if slight and occasional	up to an extent of 5 % of panel surface	Permitted, but see Note
Foreign particles	Not permitted	Not permitted	Ferrous particles not permitted		
NOTE Manufacturing defects are permitted provided that they do not impair the serviceability of the panel.					

Table 2 (continued)

Category of defect	Appearance class				
	E	I	II	III	IV
Repairs:	Practically without defects	Permitted if properly made and tightly filled up to number of:			
a) Patches		3/m ²	6/m ²	unlimited	
b) Shims					
c) Synthetic fillers	Not permitted	Not permitted	Permitted within the limits specified in the categories		unlimited
Defects at the edges of the panel due to sanding or sawing	Practically without defects	2 mm	Permitted up to 5 mm from the edge		Permitted, but see Note
Other characteristics or defects		To be considered under the category which they most closely resemble			
NOTE Manufacturing defects are permitted provided that they do not impair the serviceability of the panel.					